



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-646-213
Job Sheet 174806



Part No: D119-646-213

Job Qty: 1 ea

Part Name: AW119 Skidtube with Heavy Duty Wearplates, Float Compatible - LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.12 as per ECN12-644 DD verf:JLM IPP REV:C 12.11.05 raise to chg003 (ECN 12-675) DD verf:JLM IPP REV:D 13.03.20 raise to chg004 (ECN 13-534) DD verf:JLM IPP REV:E 14.11.25 chg004 (ECN 14-628) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	1 Ea		4/24/18	0.00	0.00	Start Up Stores/Pkg-1			APR 19 2018
110	Packaging	1 pcs		4/24/18	0.00	0.00	Packaging1-1			APR 19 2018
120	QC	1 pcs		4/24/18	0.00	0.00	QC4			APR 27 2018
125	DC	1 pcs		4/24/18	0.00	0.00	DC			APR 27 2018
130	Packaging	1 pcs		4/24/18	0.00	0.00	Packaging3-1			APR 27 2018
140	QC21-FG	1 Ea		4/24/18	0.00	0.00	QC21			APR 27 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D119-646-213 CHG 006

Descriptions: 130 - Identify and pack for shipping as per PPP D119-642-213 Location: _____ PPP rev: _____



Container No: S062909



Part: D119-646-213

Job No: 174806

Serial No/Batch: S062909

Revision:

Inspector:

Dart Aerospace Ltd.
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Date: 04/19/18

S059748 RH

Plex 3/21/18 4:00 PM Dart.Gagnon.Michelle

APR 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C50A	Bolt	8 Ea (8 ea)	90-Start up Operation	5019398
AN4C6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5027515
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	1 Ea (1 ea)	90-Start up Operation	5059748
D119-646-311	Ground Handling	1 Ea (1 ea)	90-Start up Operation	5060968
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5043981
D2712	Set Screw	12 Ea (12 ea)	90-Start up Operation	5031303
D3407-041	Tow Ring	1 Ea (1 ea)	90-Start up Operation	5054979
D3417-5	Washer	2 Ea (2 ea)	90-Start up Operation	5059573
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	5050328
D3672-3	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation	5027022
D3672-7	Washer, Phenolic	24 Ea (24 ea)	90-Start up Operation	5019309
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	5049493
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	5049436
MS21043-3	Nut	8 Ea (8 ea)	90-Start up Operation	5025206
MS21043-4	Nut	13 Ea (13 ea)	90-Start up Operation	5057534
MS21250-05-006	Bolt	8 Ea (8 ea)	90-Start up Operation	5038086
NAS1149C0332R	Washer	8 Ea (8 ea)	90-Start up Operation	IM137074
NAS1149C0432R	Washer	24 Ea (24 ea)	90-Start up Operation	5049837
NAS1149C0532R	Washer	8 Ea (8 ea)	90-Start up Operation	5025742
				5055951

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C50A	8	124	0
	AN4C6A	12	467	0
	D119-646-243	1	0	0
	D119-646-311	1	0	0
	D2652	16	548	0
	D2712	12	401	0
	D3407-041	1	14	0
	D3417-5	2	35	0
	D3456-1	1	106	0
	D3672-3	24	1,278	0
	D3672-7	24	595	0
	D3883-1	2	8	0
	D3884-1	2	11	0
	MS21043-3	8	959	0
	MS21043-4	13	652	0
	MS21250-05-006	8	86	0
	NAS1149C0332R	8	4,898	0
	NAS1149C0432R	24	2,951	0
	NAS1149C0532R	8	189	0

Part Specifications

Specifications could not be found.

Part Number: D119-646-213/-214

Description: FLOAT SKIDTUBE w/ TRAINING WEARPLATES, LH/RH

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

REFERENCE ONLY

6.2 Float Skidtubes

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
	X												D119-646-013	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-014	FLOAT SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-113	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-114	FLOAT SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-213	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-214	FLOAT SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-153	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-253	TRAINING WEARPLATES FLOAT SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3905-041	FLOAT SKIDTUBE ASSY. WITH WEARPAD
20								1					D3905-043	FLOAT SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-049	AFT WEARPLATE ASSY
29									8				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									42				AN3C5A	BOLT
32									42				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3905-045	FLOAT SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-047	FWD TRAINING WEARPLATE ASSY
45											1		D3849-045	AFT TRAINING WEARPLATE ASSY
48											1		D3847-1	WEARPAD
49											1		D3847-11	WEARPAD
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
54											10		AN3C5A	BOLT
55											10		AN960C10L	WASHER (OR NAS1149C0332R)
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C8A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)

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Revision: D
 Date: 17.02.21

Item	Qty -013	Qty -014	Qty -113	Qty -114	Qty -213	Qty -214	Qty -043	Qty -143	Qty -153	Qty -243	Qty -253	Qty -311	Part Number	Description
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	2	2	2	2	2	2							D3417-5	WASHER
82	1	1	1	1	1	1							D3458-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
90												2	D3888-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT
100	3	3	3	3									AN3C45A	BOLT
101					(3)	(3)							AN3C50A	BOLT
102	3	3	3	3									AN3C45A	BOLT
103					(3)	(3)							AN3C46A	BOLT
104					(9)	(9)							D3904-1	WASHER
109	12	12	12	12	(3)	(3)							AN960C10L	WASHER (OR NAS1149C0332R)
110	6	6	6	6	(6)	(6)							MS21043-3	NUT
111	(3)	(3)	(3)	(3)	(3)	(3)							D5101-041	CROSSBOLT SPACER ASSY
112	(6)	(6)	(6)	(6)	(6)	(6)							D5101-3	INSERT
113	(6)	(6)	(6)	(6)	(6)	(6)							D5101-5	INSERT
114	(3)	(3)	(3)	(3)	(3)	(3)							AN4-46A	BOLT
115	(6)	(6)	(6)	(6)	(6)	(6)							NAS1149D0416J	WASHER
116	(3)	(3)	(3)	(3)	(3)	(3)							MS21043-4	NUT
*120													MS21250-05048	BOLT
*121													NAS1149C0532R	WASHER
*122													D3672-7	WASHER
*123													MS21043-5	NUT
*124													D5449-1	FLOAT SADDLE WASHER

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NOT NEED TO BE INCLUDED WITH KIT.
AS THEY ARE ALREADY INSTALLED ON SKIDTUBE.

* SUPPLIED WITH DART CROSSTUBES

REFERENCE ONLY